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Quality Control

15-03-20 JFC 2015-03-27

15-03-08 4 0

15-03-28 4 9 0 15/03/28
 JFC 20150327

Work Order ID 130701

130701

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Monday, March 23, 2015 10:13:11 AM

Item ID: D2932-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle RH Out, 206
Start Date: 3/23/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 3/23/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									DAS
QC	Memo	0.00				4	0		08
Quality Control									9-89
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00				4	0	15-3-31	
Hand Finishing									
150	White.Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00				4	0	15-4-2	DAS
Powder Coating									34
	START TIME: 8:10								9-89
	FINISH TIME: 8:40								

Picklist Print

Monday, March 23, 2015 10:13:14 AM

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Work Order ID: 130701

130701

Parent Item: D2932-2

D2932-2

Parent Item Name: Saddle RH Out, 206

Start Date: 3/23/2015

Required Date: 3/23/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B00.06.26New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	20.0000	1	4			

D6101-003

Saddle Billet, 7075

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT040	4	
115091	4	
MAT044	15	
<u>120394</u>	13	
128906	2	
MAT045	1	
114314	1	

4 JFL 2015-03-27

DART AEROSPACE LTD	Work Order:	130701
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.121	.124	.125	.125		
B	0.100	0.140		.122	.124	.123	.125		
C	0.100	0.140		.119	.123	.119	.120		
D	0.210	0.230		.222	.220	.222	.222		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.512	.512	.512	.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.238	.238	.239	.239		
N	0.100	0.140		.126	.118	.122	.121		
O	0.540	0.560		.554	.546	.547	.548		
P	0.490	0.510		.502	.500	.498	.502		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.493	2.492	2.492	2.493		
S	0.240	0.270		.255	.250	.248	.251		
T	0.100	0.180		.140	.138	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.136	1.135	1.137	1.136		
Y	1.565	1.585		1.574	1.574	1.577	1.576		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JFC
Date:	2015-03-07

Audited by:	S.A	DAS
Date:	15/03/31	08
		9-89

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED 	APPROVED 	DRAWING NO. D2922	REV. A SHEET 1 OF 2
DATE 99.10.14		TITLE OH-58 SKIDTUBE ASSEMBLY SCALE NTS	
A	99.10.14	NEW ISSUE	
A1	CP 01.08.20	Ø0.640 WAS Ø0.625	

RELEASED
00.05.11

Qty	Part Number	Description
X	D2922-041	SKIDTUBE ASSEMBLY
*	D2600-1	EXTRUSION
1	D2646	AFT CAP.
4	D2648-3	WEARPAD
1	D2648-5	WEARPAD
22	D2649	CROSS BOLT SPACER
20	D2651-1	PLUG
20	D2651-3	O-RING
1	D2656-15	WEARSHOE
1	D2656-21	WEARSHOE
1	D2794	CAP
1	D2923	WEB
1	D2924	WEARSHOE
50	AKS7-1032-130 or AKS4-1032-130 or ALS7-1032-130 or ALS4-1032-130	INSERT
52	AN960JD10L	WASHER
52	MS27039-1-08	SCREW

130701 MJS
1503-23

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2600-1 EXTRUSION REQUIRED BEFORE BENDING = 160 INCHES.*
- 3) INSERT D2923 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8406 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL AKS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN ALL INSERTS. SEAL WITH SIKAFLEX-241/291.
- 5) WELDING TO BE DONE PER DART QSI 004.
- 6) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2923 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 0.50 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 7) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (20 PLACES).



Part Number: D2932-2	Rev: C	- Page 1 -
Description: SADDLE OUTSIDE	Inspection Dwg: D2932	Work Order: 130701

Name	Nominal	Upper Tol Lower Tol	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	
D Distance YZ	0.2200	0.0100 -0.0100	0.2241	0.2192	0.2189	0.2203	
E Distance XY	1.2500	0.0050 -0.0050	1.2498	1.2501	1.2511	1.2494	
F Distance XY	1.2500	0.0050 -0.0050	1.2493	1.2494	1.2498	1.2498	
G Distance XY	2.5000	0.0050 -0.0050	2.4995	2.5009	2.4987	2.4998	
I Distance XY	1.5770	0.0050 -0.0050	1.5780	1.5774	1.5778	1.5770	
J Distance XY	2.5000	0.0050 -0.0050	2.4999	2.4998	2.4995	2.4995	
K Diameter	0.2570	0.0050 -0.0010	0.2582	0.2574	0.2564	0.2565	
L Diameter	0.3120	0.0050 -0.0010	0.3128	0.3129	0.3111	0.3125	
N Distance YZ	0.1200	0.0200 -0.0200	0.1254	0.1173	0.1201	0.1214	
O Distance XY	0.5500	0.0100 -0.0100	0.5538	0.5468	0.5484	0.5489	
P Distance XY	0.5000	0.0100 -0.0100	0.5016	0.5003	0.5025	0.5025	
Q Distance XY	3.7200	0.0050 -0.0050	3.7200	3.7192	3.7189	3.7186	
R Distance XY	2.4900	0.0200 -0.0200	2.4953	2.4947	2.4945	2.4946	
U Distance XY	1.6300	0.0050 -0.0050	1.6298	1.6303	1.6299	1.6302	
V Distance XY	1.3670	0.0050 -0.0050	1.3682	1.3678	1.3676	1.3669	
W Diameter	0.3160	0.0050 -0.0010	0.3151	0.3153	0.3149	0.3150	
Z Radius	0.1880	0.0100 -0.0100	0.1967	0.1965	0.1967	0.1966	

Measured by:
Mathieu Lamarche

Date:
2015-3-29

Audited by:

Date: